

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-594 Rev. C (AND EARLIER) AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-594 Rev. 2 (AND EARLIER)
REF. CANADIAN STC: SH03-6
REF. FAA STC: SR01742NY

For D205-596-101/-103 Crosstubes (ref. 39" Landing Gear) or D205-596-105/-107 Crosstubes (ref. 31" Landing Gear) at CHG 002 or later, the D2856-600-851/-1009 Abrasion Strips have been removed, the MS21920-25 Clamp replaces the MS21920-24 Clamps, the D2893-1 and D2940-1 Supports have been bonded onto the crosstubes using Magnobond 6398 and D3595-063-450/-530 Rubber Cushions have been installed underneath the MS21920-25/-28 Clamps. Amend Parts List of IIN-D205-594 Section 5 and ICA-D205-594 Section 32.8 as follows:

Remove:

QTY -101	QTY -103	QTY -105	QTY -107	Part Number	Description
2		2		D2856-600-851	ABRASION STRIP
	2		2	D2856-600-1009	ABRASION STRIP
4		4		MS21920-24	CLAMPS

Add:

QTY -101	QTY -103	QTY -105	QTY -107	Part Number	Description
4		4		D3595-063-450	RUBBER CUSHION
	4		4	D3595-063-530	RUBBER CUSHION
4		4		MS21920-25	CLAMP

To prevent the supports from shifting on D205-596-101/-103/-105/-107 Crosstubes at CHG 001, the D2893-1 or D2940-1 Supports should be removed and re-installed as follows:

- 1) Follow section 32.1 of ICA-D205-594 for the removal of the crosstubes from the helicopter.
 - 2) Remove the MS21920-24/-28 Clamps that fasten the D2893-1 and D2940-1 Supports from the crosstubes per Section 32.3 of ICA-D205-594.
 - 3) Remove the D2856-600-851/-1009 Abrasion Strips from the crosstube per section 32.5 of ICA-D205-594.
 - 4) Inspect the crosstube surface underneath the supports for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection. Repair damage within acceptable limits and touch up finish per item 5.3.3 of the 300 hour inspection.
 - 5) Inspect the supports for corrosion and mechanical damage per items 5.3.4 of the 300 hour inspection. Repair damage within acceptable limits and touch up finish per item 5.3.4 of the 300 hour inspection.
 - 6) Abrade area to which support will be applied with 400 grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe area until there is no residue.
 - 7) Apply a 0.03" to 0.06" thick layer of Magnobond 6398 underneath D2893-1 or D2940-1 Supports and re-install the Supports on the crosstube as shown in Figure 1. Install a D3595-063-450/-530 Rubber Cushion on each MS21920-25/-28 Clamp. Position and secure the D2893-1 or D2940-1 Supports on the crosstube using MS21920-25/-28 Clamps. Torque clamps to 80-100 in-lb. Let the D205-596-101/-103/-105/-107 Crosstube Assembly cure before re-installing the crosstube on the aircraft.
- Note:** It is acceptable to substitute the MS21920-25/-28 with longer or shorter clamps to accommodate varying diameters. Ensure there is a minimum of 1.5 threads in safety on the nut.
- 8) Re-install the D205-596-101/-103/-105/-107 crosstube per section 32.2 of ICA-D205-594.

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
DATE:	07.12.04
CERT. NO.:	SH03-6
ISSUE NO.:	3

B	REPLACE MS21920-24 WITH MS21920-25 ON -101/-105; ADDED EXTRA NOTE TO INSTALLATION PROCEDURE (STEP 7)			MB	07.12.04	
A	NEW ISSUE			MB	07.11.16	
REV.	DESCRIPTION			BY	DATE	
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN	<i>[Signature]</i>					
CHECKED	<i>[Signature]</i>				DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>				DSI 9396	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>				TITLE	SCALE
DE APPR.	<i>[Signature]</i>				CROSSTUBE SUPPORT CHANGE	
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For customers who would like to upgrade their D205-596-101/-103/-105/-107 Crosstubes from CHG 001 to CHG 002, the following kits can be obtained from Dart:

DSI 9396-XXX PARTS LIST

QTY -011	QTY -013	Part Number	Description
X		DSI 9396-011	FWD CROSSTUBE SUPPORT CHANGE (D205-596-101/-105 FWD CROSSTUBE)
	X	DSI 9396-013	AFT CROSSTUBE SUPPORT CHANGE (D205-596-103/-107 AFT CROSSTUBE)
4		D3595-063-450	RUBBER CUSHION
4		MS21920-25	CLAMP
4		D3595-063-530	RUBBER CUSHION
4		MS21920-28	CLAMP

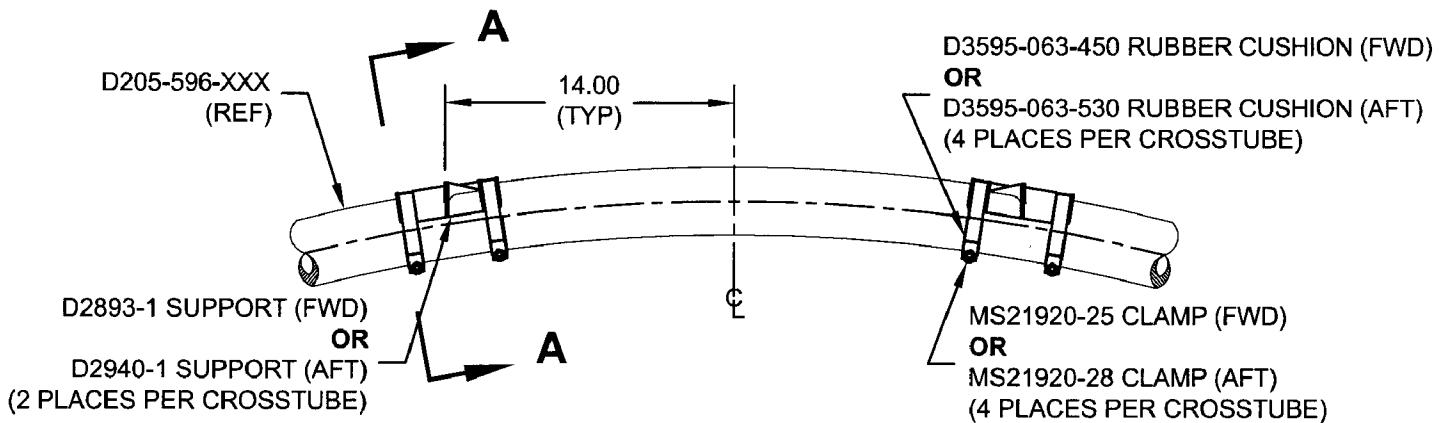
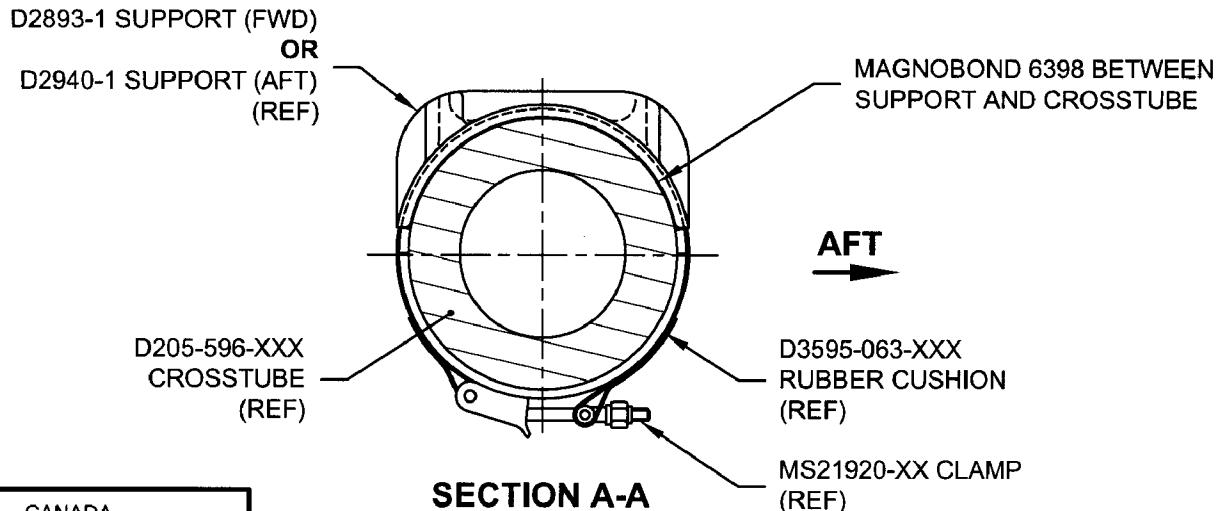


FIGURE 1: INSTALLATION OF SUPPORT ON CROSSTUBE



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MFG. APPR.	<i>[Signature]</i>	DSI 9396	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	
DE APPR.	<i>[Signature]</i>	CROSSTUBE SUPPORT CHANGE NTS	
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